

Date: Tuesday, 12/18/2007 10:51:24 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 36424		
Estimate Number	: 12734		
P.O. Number	: <i>N/A</i>	Part Number	: D353525
This Issue	: 12/18/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3535 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 35564	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/15/2008
Checked & Approved By	: <i>[Signature]</i>	Qty:	20 Um: Each
Comment	Est Rev: A New Issue 07-02-15 JLM Est Rev: B As per Rev B 07-08-31 JLM Verified By: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.5355 sf(s)/Unit Total : 10.7100 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: *106292* *B 07-12-20*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: *B*
 Prog Rev: *B*

*B 07-12-20**(20)*

2-Deburr if necessary

B 07-12-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 07/12/08 (20) cuts

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326
 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

SBS 02/01/08 (20)
[Signature] 02/01/08 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 08/07/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/18/2007 10:51:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 36424

Part Number: D353525

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/09 (20X)

7.0

POWDER COATING

POWDER COATING



M105642



(20X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08/01/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



YJ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-09

(20X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

YJ

08-01-09

(20X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/09

Job Completion



08/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36424
Description: Wearshoe		Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	X			
1.937	+/-0.010	1.937	X			
1.450	+/-0.010	1.450	X			
5.450	+/-0.010	5.455	X			
10.900	+/-0.010	10.900	X			
16.350	+/-0.010	16.350	X			
21.800	+/-0.010	21.800	X			
Ø0.188	+0.005/-0.001	.189	X			
12.750	+/-0.010	12.750	X			
6.75	+/-0.030	6.75	X			
6.00	+/-0.030	6.00	X			
0.300	+/-0.010	.305	X			
0.300	+/-0.010	.305	X			
0.038	+/-0.010	.036	X			

Measured by: JB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07-12-20	Date: 07/12/21	Date:	N/A

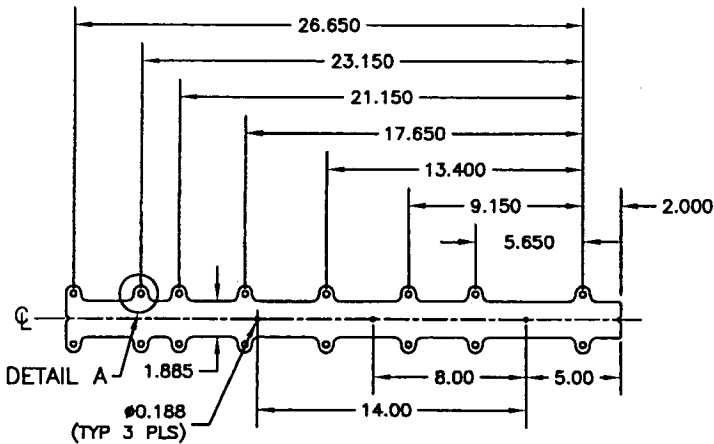
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	[Signature]

DART

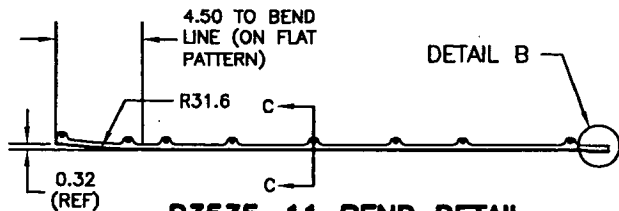
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07.04.24

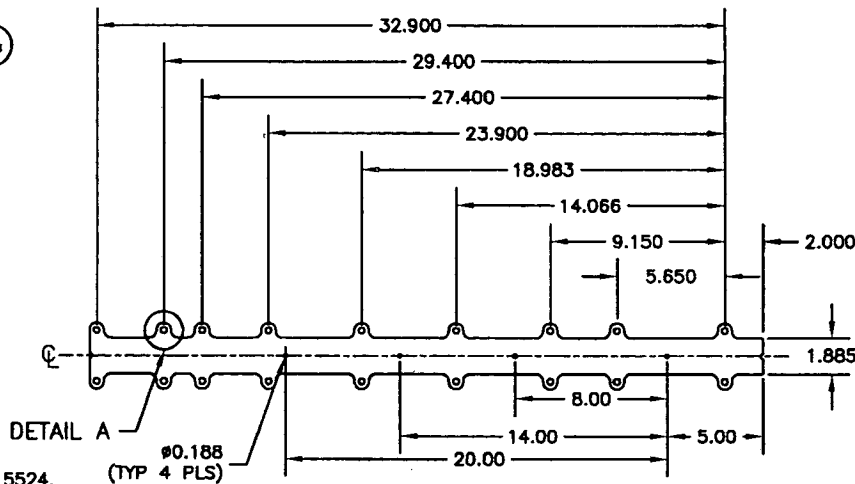
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 1 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	



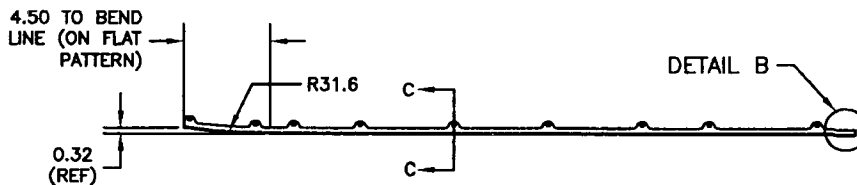
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

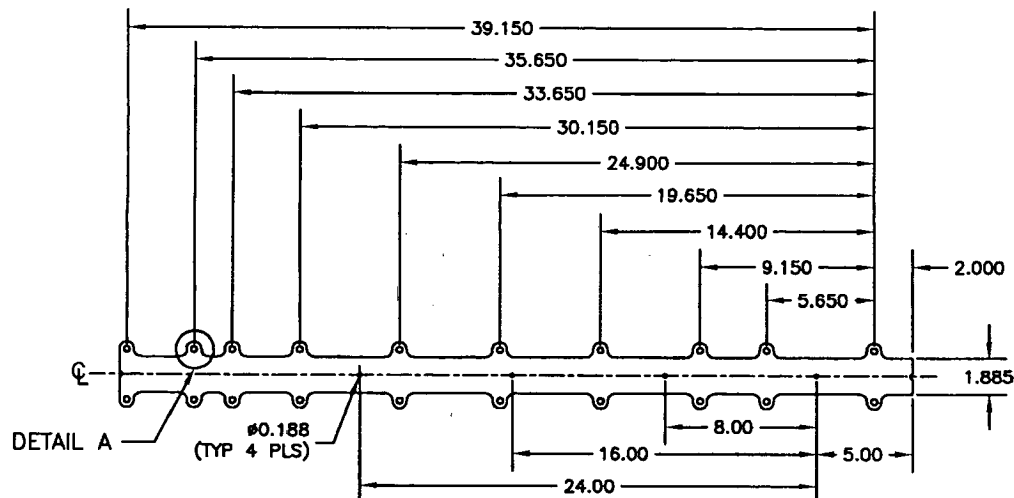
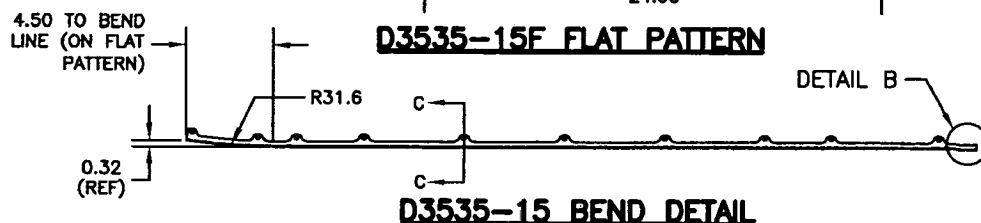
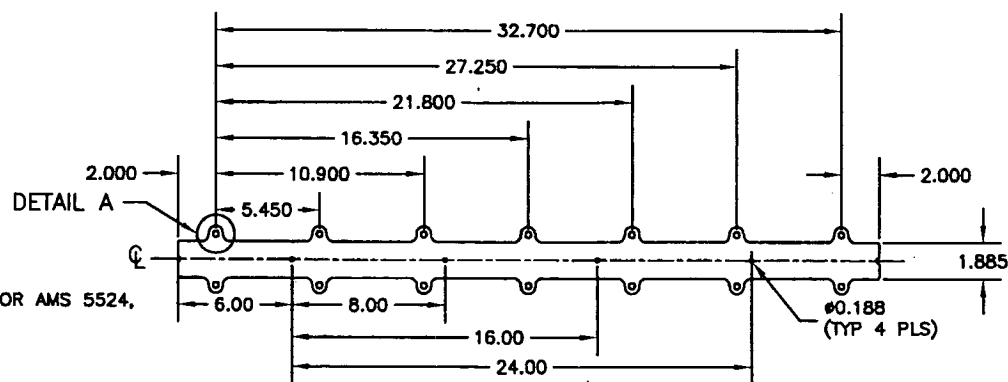
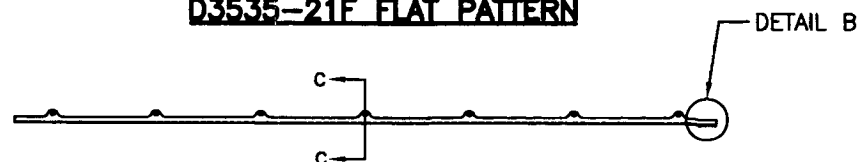
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<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 2 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

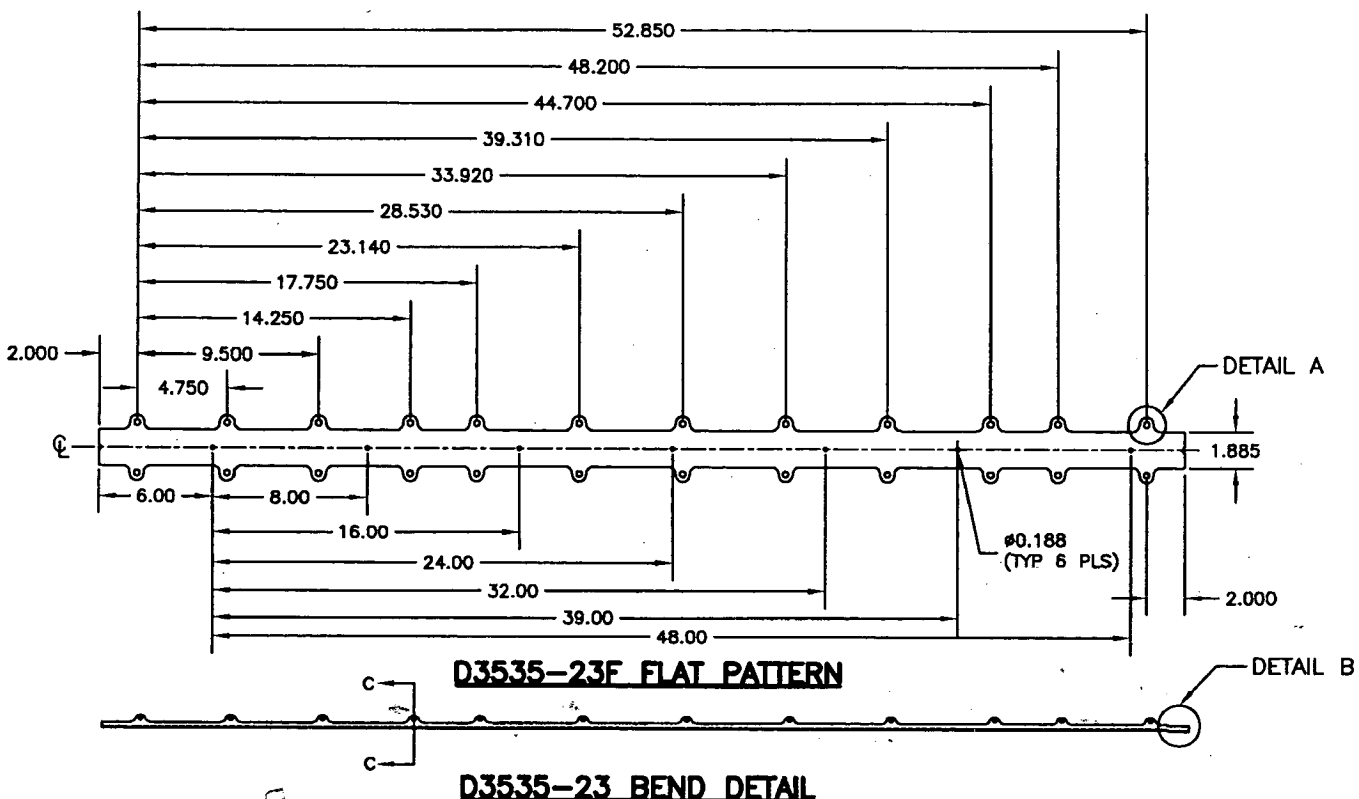
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DATE	07.04.17	TITLE	D3535	WEARSHOE
				REV. B
				SHEET 3 OF 7
				SCALE
				1:10

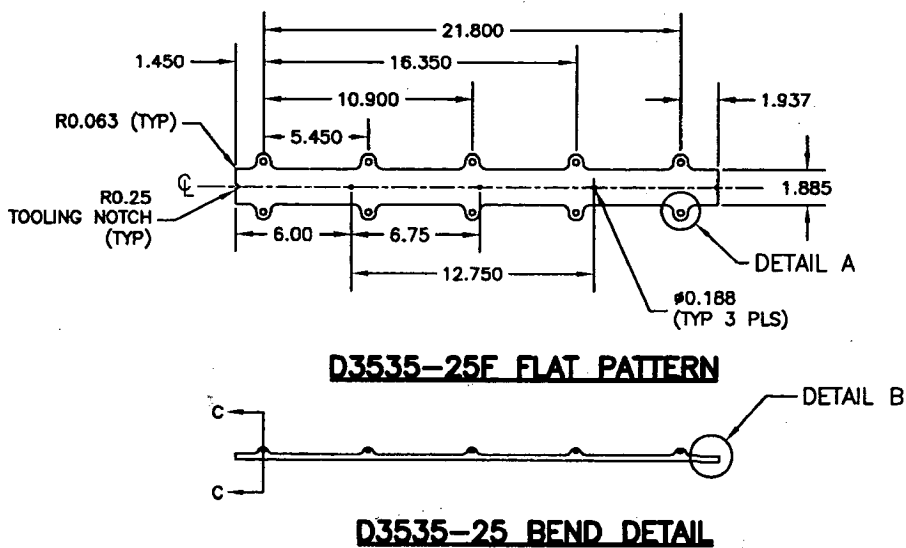
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D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

NOTES

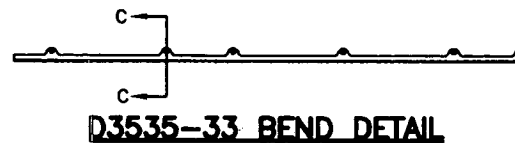
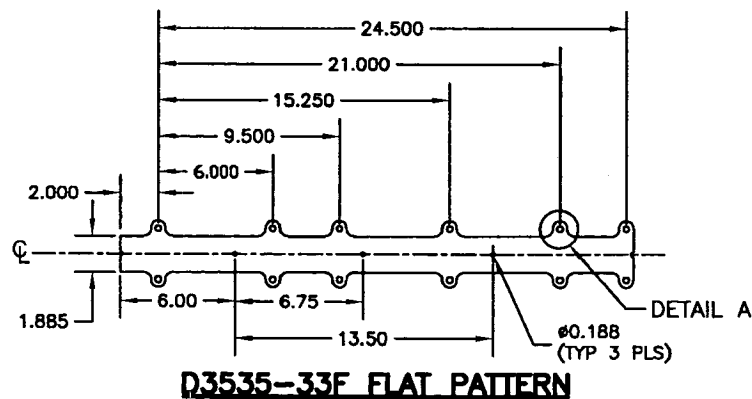
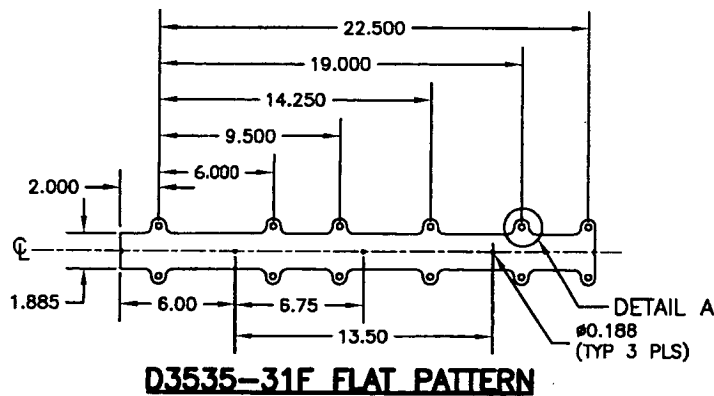
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	



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NOTES

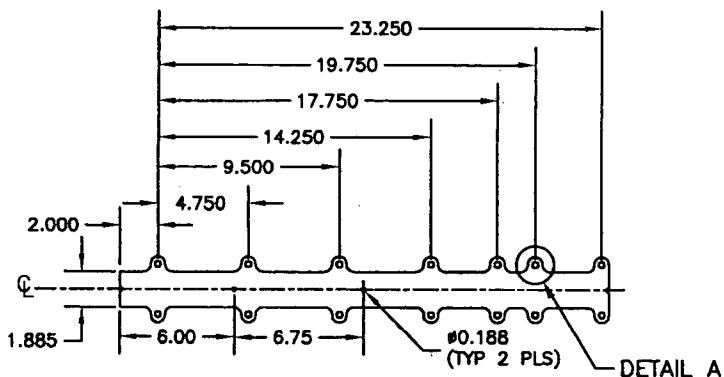
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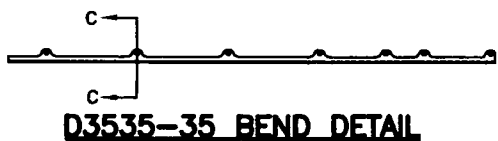
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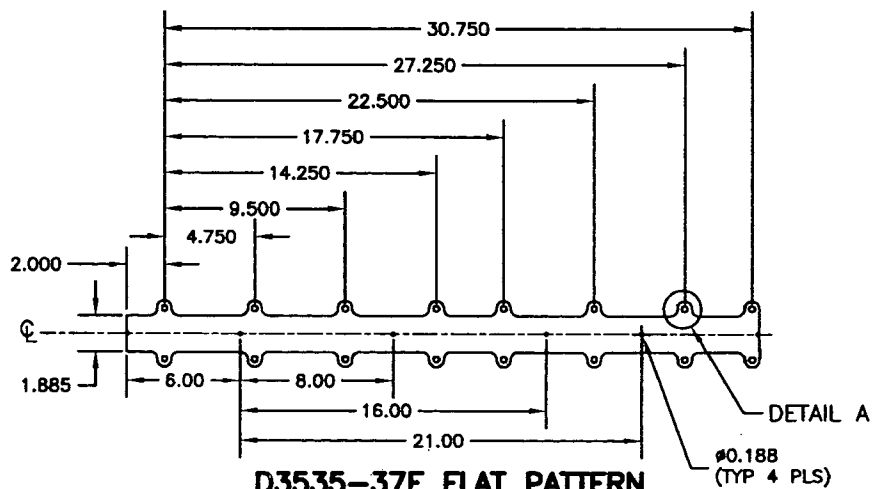
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<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 5 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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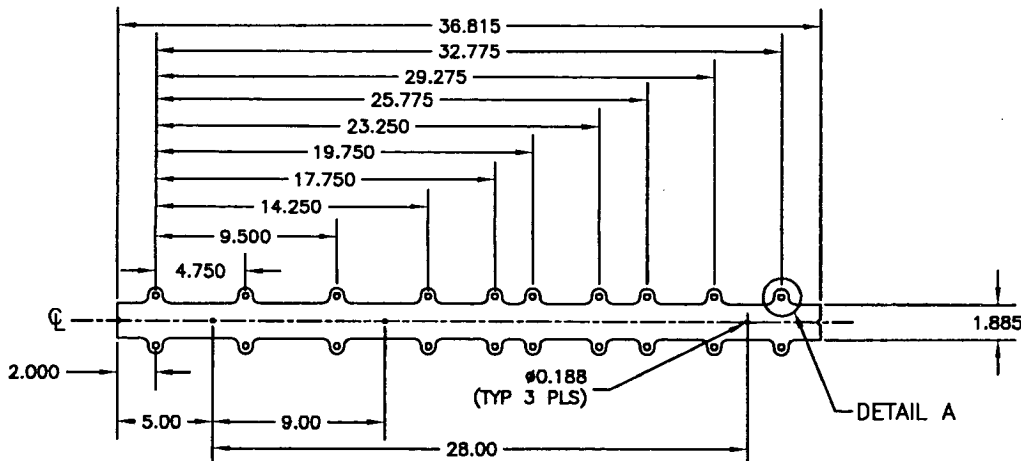
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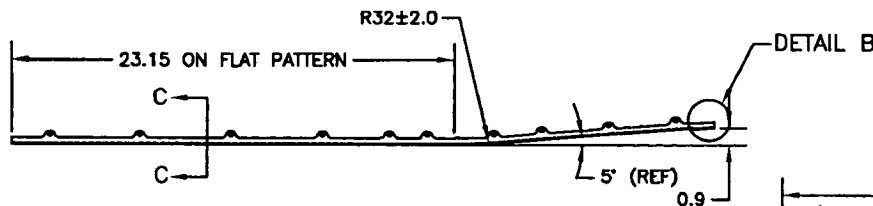
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



D3535-39F FLAT PATTERN

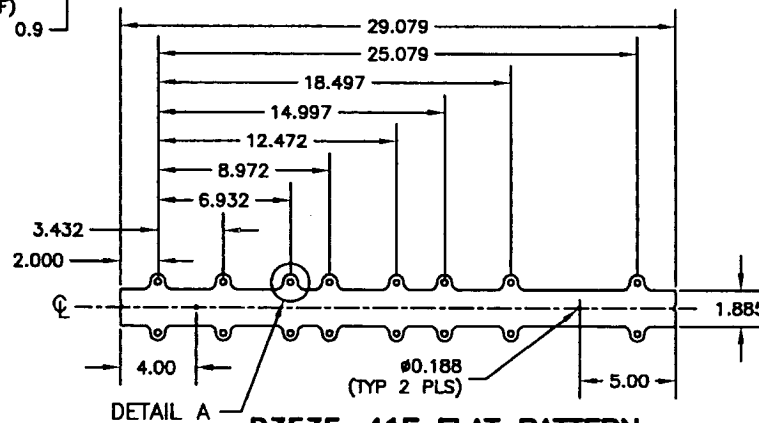


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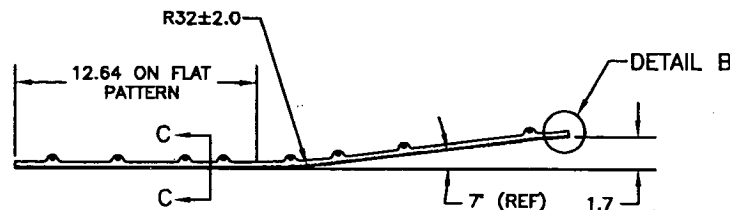
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WORK ORDER
NO 36424

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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D3535-41F FLAT PATTERN

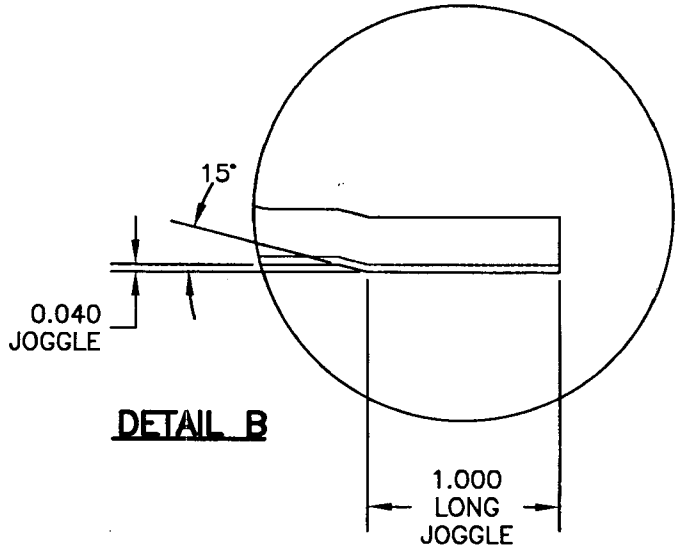


D3535-41 BEND DETAIL

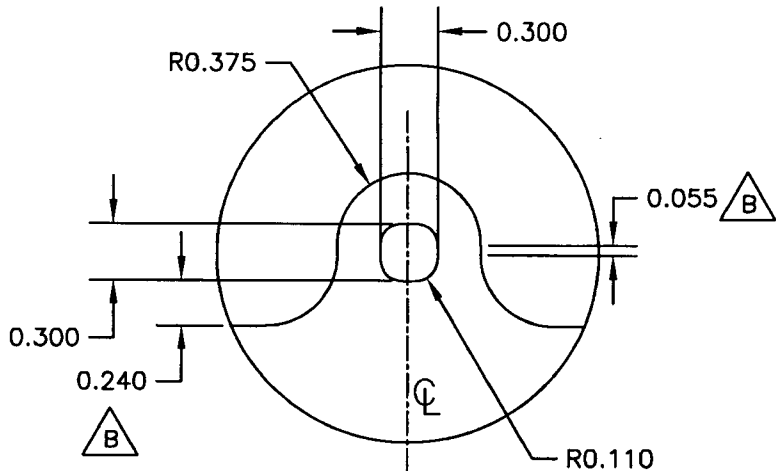


DESIGN	C.B.	DRAWN BY	M.H.	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3535
DATE	07.04.17			REV. B
				SHEET 7 OF 7
				SCALE 1:1
				TITLE WEARSHOE

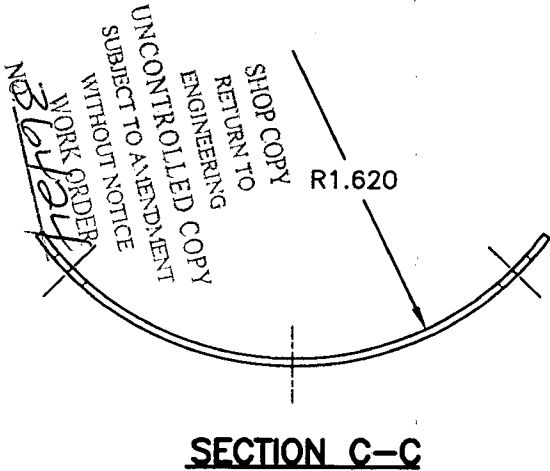
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DETAIL B



DETAIL A



SECTION C-C